

Date: Wednesday, 5/16/2007 1:28:57 PM
 User: Kim Johnston

Process Sheet

22

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 STEP(STANDARD HEIGHT)
 Job Number : 32389
 Estimate Number : 10180
 P.O. Number : *N/A* Part Number : D205633011
 This Issue : 5/16/2007 S.O. No. : Drawing Number : *N/A*
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *1/1* Type : LARGE FAB ASSY Drawing Revision : *N/A*
 Previous Run : 32382 Material : *N/A*
 Due Date : 5/30/2007 Qty: 10 Um: Each
 Written By : *HA 07.05.16*
 Checked & Approved By : *HA 07.05.16*
 Comment : Est Rev: F 02.07.11 Reformat; Removed D3010 RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 32389A STEP WELDMENT



Comment: Sub-Component STEP WELDMENT
 D2563 B *323824*

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPP205-633-011 CHG001

KS 07/05/18

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0 D2021101 Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 1 D2021-101 Eyebolt *B27334* ✓

5.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 2 D2022-101 Spacer *B30543* ✓

EP 07/06/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:28:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 32389

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer

B25967 +

7.0

D2562001

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-001 Strut

B30549 (8x) ✓

8.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-101 Strut

B32464 (6x) ✓ B27647 (4x) ✓

9.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-103 Strut

B28789 (9x) ✓

10.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-105 Strut

B30550 x9 / x1 B23184 ✓

11.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-107 Strut

B27648 (5x) ✓ B32462 (5x) ✓

B04/06/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:28:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 32389

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-109

Strut

B27408 (5X)

B32462 (5X) ✓

13.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-111

Strut

B28790 (9X) ✓

B32464 (2X) ✓

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A

Bolt

M100857 ✓

15.0

AN46A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A

Bolt

M103962 ✓

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A

Bolt

M102140 ✓

CFL 5/16/14 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:28:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 32389

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A

Bolt

M102473 X

18.0

AN56A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A

Bolt

M18576 X

19.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A

Bolt

M101291 X

20.0

AN960JD416

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416

Washer

M103691 X

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M103641 X

EP 07/06/14 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:28:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 32389

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut

1102552 ✓

23.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut

1102536 ✓

EP 5/7/06/13 (10)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/6/14 (#8)

C207106114 (#8)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-011

Location:

Rev 4

7/6/15 SP

EP 7/6/15

26.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

PC 7/6/15

Job Completion



U 07/06/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries